

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claims 1-50 (canceled)

1 Claim 51 (currently amended): A method for manufacturing
2 products (1, 30, 40) in a mold, said products comprising at
3 least natural polymers ~~such as starch~~, wherein said
4 products are manufactured by bringing masses into or through
5 a mold (60, 70, 80) which are heated within said mold, such
6 that this involves at least cross-linkage of the natural
7 polymers, while of at least one first part (6, 36, 85) of
8 the product (1, 30, 40), the material composition is
9 influenced such that the material properties of the relevant
10 first part (6, 36, 85) deviate from the material properties
11 of parts adjoining said part, wherein as masses at least a
12 first mass (M1) and a second mass (M2) are used wherein the
13 first mass (M1) and a second mass (M2) are used wherein the
14 first mass (M1) differs in composition from the second
15 mass (M2) prior to introduction into or through said mold
16 (60, 70, 80) and wherein the at least one first part (6,
17 36, 85) of the product (1, 30, 40) is formed from said
18 second mass (M2) and at least one part ~~and preferably all~~
19 parts (2, 4, 32, 36, 87, 89, 48) adjoining the relevant first
20 part (6, 36, 85) are formed of said first mass (M1).

1 Claim 52 (previously presented): A method according to
2 claim 51, wherein at least one of said at least one first

3 part (6, 36, 85) in the mold is formed such that a
4 relatively high concentration of softener is obtained
5 and/or maintained herein, such that the flexibility of the
6 relevant at least one front part (6, 36, 85) is greater than
7 the flexibility of parts (2, 4, 32, 36, 87, 89, 48)
8 adjoining said part.

1 Claim 53 (currently amended) : A method according to
2 claim 51, wherein the second mass is selected from ~~a~~the
3 group consisting of masses ~~comprising~~of relatively much
4 softener and/or softener retaining components compared to
5 said first mass (M1) such that after the manufacture of the
6 product, so much softener or softener of such nature remains
7 behind in the relevant first part (6, 36, 85) that the
8 pliability thereof is greater than the pliability of wall
9 parts of parts (2, 4, 32, 36, 48, 87, 89) adjoining said
10 part made of said second mass.

1 Claim 54 (currently amended) : A method according to
2 claim 51, wherein the second mass is selected from ~~a~~the
3 group of masses ~~comprising~~consisting of relatively little
4 softener or softener retaining components compared to said
5 first mass (M1), such that after the manufacture of the
6 product, such small amount of softener or softener of such
7 mature remains behind in the relevant first part (6, 36, 85)
8 that the brittleness of at least a part thereof is greater
9 than that of wall parts (2, 2, 32, 36, 48, 87, 89) adjoining
10 said part made of said first mass (M1).

1 Claim 55 (currently amended) : A method according to
2 claim 51, wherein the first and second masses are selected
3 from the groups of masses ~~having~~consisting of different

4 types and/or amounts of fibers, the second mass is being
5 selected such that after the manufacture of the product, a
6 concentration and/or orientation of fibers is obtained
7 and/or type of fibers is included in the relevant first part
8 (3, 36, 85) which deviates from the concentration,
9 orientation and/or nature of any fibers present in other
10 parts (2, 4, 32, 36, 48, 87, 89).

1 Claim 56 (currently amended) : A method according to
2 claim 51, wherein the first and second masses are selected
3 from groups of masses having consisting of different types
4 and/or amounts of blowing agents and/or fillers, the second
5 mass is being selected so that at least during the
6 manufacture of the product, a concentration of and/or type
7 of blowing agent and/or filler is obtained in the relevant
8 first part (6, 36, 85) which deviates from that in other
9 parts (2, 4, 32, 36, 48, 87, 89) of the product, to obtain a
10 product in which, in the relevant first part (6, 36, 85), a
11 structure is realized whose density deviates from the
12 density of other parts (2, 4, 32, 36, 48, 87, 89) of the
13 product.

1 Claim 57 (currently amended) : A method according to
2 claim 51, wherein the first and second masses are selected
3 from groups of masses having consisting of different types
4 and/or amounts of colorants, wherein the second mass is
5 selected so that in the relevant first part (6, 36, 85), a
6 concentration of and/or a type of colorant is obtained which
7 deviates from that in other parts (2, 4, 32, 36, 48, 87, 89)
8 of the product, to obtain a product in which the relevant
9 first part (6, 36, 85) has a color deviating from that of
10 other parts (2, 4, 32, 36, 48, 87, 89) of the product.

1 Claim 58 (currently amended) : A method according to
2 claim 51, wherein the first and second masses are selected
3 from groups of masses havingconsisting of different types
4 and/or concentrations of cross-linkers, wherein the second
5 mass is selected so that at least during the manufacture of
6 the product, a concentration of and/or a type of
7 cross-linkers is obtained in the relevant first part (6, 36,
8 85), a concentration of and/or a type of cross-linkers is
9 obtained which deviates from that in other parts (2, 4, 32,
10 36, 48, 87, 89) of the product, to obtain a product in which
11 the relevant first part (6, 36, 85) has a structure whose
12 density deviates from the density of other parts (2, 4, 32,
13 36, 48, 87, 89) of the product.

1 Claim 59 (previously presented) : A method according to
2 claim 51, wherein the second mass is introduced between two
3 flows of first mass.

1 Claim 60 (previously presented) : A method according to
2 claim 51, wherein the second mass is introduced into a mold
3 in a zone forming the relevant first part (6, 36, 85), while
4 the first mass is introduced into a number of zones forming
5 parts (2, 4, 32, 36, 48, 87, 89) adjoining said first zone,
6 such that in the closed mold, the first mass and the second
7 mass are forced against each other and interconnected.

1 Claim 61 (previously presented) : A method according to
2 claim 51, wherein the first and second mass in the mold are
3 interconnected prior to or at least at the start of the
4 occurrence of cross-linkage of the natural polymers.

1 Claim 62 (previously presented): A method according to
2 claim 51, wherein the first mass and the second mass are
3 introduced into the mold out of phase, while preferably the
4 introduction of the second mass is started prior to the
5 introduction of the first mass.

1 Claim 63 (previously presented): A method according to
2 claim 51, wherein the first mass in the mold is subjected to
3 a first pressure and the second mass in the mold is
4 subjected to a second pressure, the first pressure deviating
5 from the second pressure.

1 Claim 64 (previously presented): A method according to
2 claim 51, wherein the or each mass is introduced into the
3 mold under a pressure higher than atmospheric, preferably
4 through injection molding.

1 Claim 65 (previously presented): A method according to
2 claim 51, wherein at least three different masses are used
3 for the manufacture of the product.

1 Claim 66 (previously presented): A method according to
2 claim 51, wherein at least the at least one first part (6,
3 36, 85), after formation in the mold, is processed such that
4 the material properties of said relevant first part (6, 36,
5 85), are changed, at least relative to parts (2, 4, 32, 36,
6 48, 87, 89) adjoining said part (6, 36, 85).

1 Claim 67 (previously presented): A method according to
2 claim 51, wherein at least a portion of the at least one
3 first part (6, 36, 85), a first coating is applied, said
4 coating comprising at least a component active with the

5 relevant first mass, such that between the relative active
6 component and the mass, there is obtained a reaction whereby
7 the material properties of the relevant first part (6, 36,
8 85) are influenced.

1 Claim 68 (previously presented): A method according to
2 claim 67, wherein at least the parts (2, 4, 32, 36, 48, 87,
3 89) adjoining the first part (6, 36, 85) are covered prior
4 to the application of the first coating.

1 Claim 69 (previously presented): A method according to
2 claim 68, wherein at parts (2, 4, 32, 36, 48, 87, 89)
3 adjoining the first part (6, 36, 85) are at least partially
4 covered by a second coating, substantially impermeable to
5 said reactive component of the first coating, such that the
6 first part (6, 36, 85) is at least partially kept clear of
7 the second coating.

1 Claim 70 (previously presented): A method according to
2 claim 69, wherein a second coating is used having a high
3 hardness relative to the first coating, a relatively low
4 permeability and high resistance to at least said reactive
5 component.

1 Claim 71 (previously presented): A method according to
2 claim 69, wherein the first coating is applied over the
3 second coating.

1 Claim 72 (previously presented): A method according to
2 claim 67, wherein as first coating, a water based coating is
3 used.

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1 Claim 73 (previously presented) : A method according to
2 claim 67, wherein as first coating, a relatively flexible
3 elastic coating is used.

1 Claim 74 (currently amended) : A method according to
2 claim 67, wherein as first coating, a coating is
3 used selected from the group consisting of comprising a number
4 of constituents from the group of: acrylic binders,
5 lattices, styrene-butadiene latex, polyvinyl alcohol,
6 polyvinyl acetate, polyacrylates, polyethylene glycol,
7 polylactic acid, synthetic polymers, natural polymers,
8 natural waxes, synthetic waxes (for instance polyethylene
9 waxes) or derivatives thereof or combinations of the
10 preceding.

1 Claim 75 (currently amended) : A method according to
2 claim 69, wherein as second coating, a coating is used
3 comprising a number of constituents from the group
4 consisting of: melamine, acrylic binders, water resistant
5 lacquers (for instance cellulose lacquer), cellulose acetate
6 propianates, polyethylene, polyacrylates, synthetic
7 polymers, natural polymers, synthetic waxes, natural waxes,
8 polyactic acid, derivatives thereof or combinations of the
9 preceding.

1 Claim 76 (currently amended) : A method according to
2 claim 74, wherein cross-linkers are incorporated into the
3 first and/or second coating, in particular selected from the
4 group consisting of zirconium acetate, ammonium zirconium
5 carbonate, urea formaldehyde, melamine formaldehyde,

6 glyoxal, polyamideamine-epichlorohydrin, epoxides,
7 trimetaphosphate, derivatives thereof or combinations of the
8 preceding.

1 Claim 77 (previously presented) : A method according to
2 claim 74, wherein in the first coating, at least one of the
3 waxes is combined with at least one of the said other
4 constituents.

1 Claim 78 (previously presented) : A method according to
2 claim 74, wherein the first, respectively second coating is
3 formed almost entirely from one of said constituents.

1 Claim 79 (currently amended) : A method according to
2 claim 51, wherein the first part (6, 36, 85) is designed as
3 a hinge part 6 having at least one recess, in particular at
4 least one groove extending over the width of the hinge part
5 is provided.

1 Claim 80 (previously presented) : A method according to
2 claim 51, wherein into the first part (6, 36 85), after
3 cross-linking of the natural polymers, a softener is
4 introduced.

1 Claim 81 (previously presented) : A method according to
2 claim 51, wherein a reactive component is incorporated into
3 the first part (6, 36, 85), outside the mold, while it is at
4 least substantially prevented from flowing away to the other
5 parts, preferably a softener having a relatively large
6 particle size and/or high viscosity.

1 Claim 82 (currently amended) : A method according to
2 claim 81, wherein as reactive component, at least a fatty,
3 oily or waxy ingredient ~~or the like~~is used.

1 Claim 83 (currently amended) : A method according to
2 claim 51, wherein ~~as the softener,~~ is selected from the group
3 consisting of ~~at least one from the following group is used:~~
4 water, polyols, glycol, glycerol, glycerin, polyethylene
5 glycol, polypropylene glycol, propylene glycol, sorbitol,
6 glucose derivatives thereof or combinations of preceding
7 softeners.

1 Claim 84 (previously presented) : A method according to
2 claim 51, wherein at least during a portion of the
3 cross-linking of the natural polymers, the first part is at
4 least partially compressed.

1 Claim 85 (previously presented) : A method according to
2 claim 51, wherein in or on at least the first part, an
3 active component is provided for adjusting the surface
4 tension of at least said first part of the product with
5 cross-linked natural fibers, in particular for increasing
6 the surface tension.

1 Claim 86 (previously presented) : A method according to
2 claim 51, wherein to at least a part of the product, a
3 coating is applied whose surface tension is approximately
4 equal to or lower than the surface tension of the product
5 part to which the coating is applied.

1 Claim 87 (previously presented): A method according to
2 claim 51, wherein a coating is applied to the product, said
3 coating comprising cross-linkers for the mass, in particular
4 natural polymers incorporated therein.

1 Claim 88 (previously presented): A method according to
2 claim 51, wherein at least two coatings are applied at least
3 partially one over the other, at least one of the coatings
4 comprising an active component capable of reacting with the
5 at least one other coating.

1 Claim 89 (previously presented): A method according to
2 claim 88, wherein as active component, at least cross-
3 linkers are used.

1 Claim 90 (previously presented): A method according to
2 claim 67, wherein the product is gripped at the first part
3 (6, 36, 85), such that it is covered at least substantially
4 completely, after which the second coating is applied to
5 other parts (2, 4, 32, 36, 48, 87, 89), in particular
6 sprayed thereon, after which the first part is released and,
7 after that, the second coating is applied, in particular
8 sprayed thereon.

Claims 91-100 (canceled).